

Date: Wednesday, 21/01/2009 9:14:41 AM  
 User: Linda Lacelle

## Process Sheet

split

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 45006  
 Estimate Number : 11156  
 P.O. Number :  
 This Issue : 21/01/2009 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : PURCHASED PARTS  
 Previous Run : 43628  
 Written By :  
 Checked & Approved By :  
 Comment : Est A: 05.03.03 New issue KJ/JLM  
 Est B: 08.11.28 QC6 moved to step 4 KJ Verified by: EC

Drawing Name : TIRE AND RIM ASSEMBLY  
 Part Number : D32339  
 Drawing Number : D3233  
 Project Number : N/A  
 Drawing Revision : B  
 Material :  
 Due Date : 28/01/2009 Qty: 20 Um: 1 ach

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 8012 C209101121  
 For D3233-9 Tire and Rim Assembly P/N: 8353T74  
 Possible Supplier: McMaster-Carr  
 Product Specification sheet is required

20  
 20

2.0 8353T74 TIRE &amp; RIM



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)  
 Tire & Rim Assembly

3.0 PACKAGING 1 PACKAGING RESOURCE: #1



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage  
 Ensure Product Specification sheet is attached  
 Identify and Stock  
 Location: \_\_\_\_\_

R 9/9/23 10

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 08/01/26 415

5.0 PACKAGING 1 PACKAGING RESOURCE: #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
 Location: WA

SAD 09-03-25 15

Date: Wednesday, 21/01/2009 9:14:41 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TIRE AND RIM ASSEMBLY

Job Number: 45006

Part Number: D32339

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/25

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

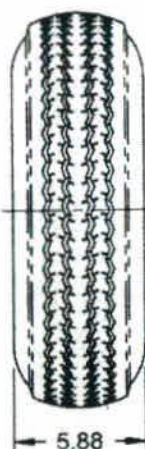
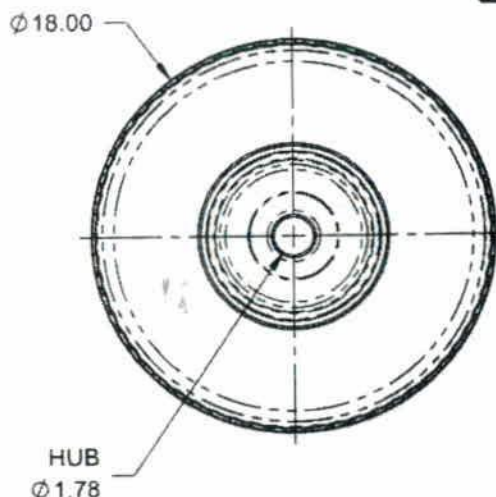


09/03/25



**DART**

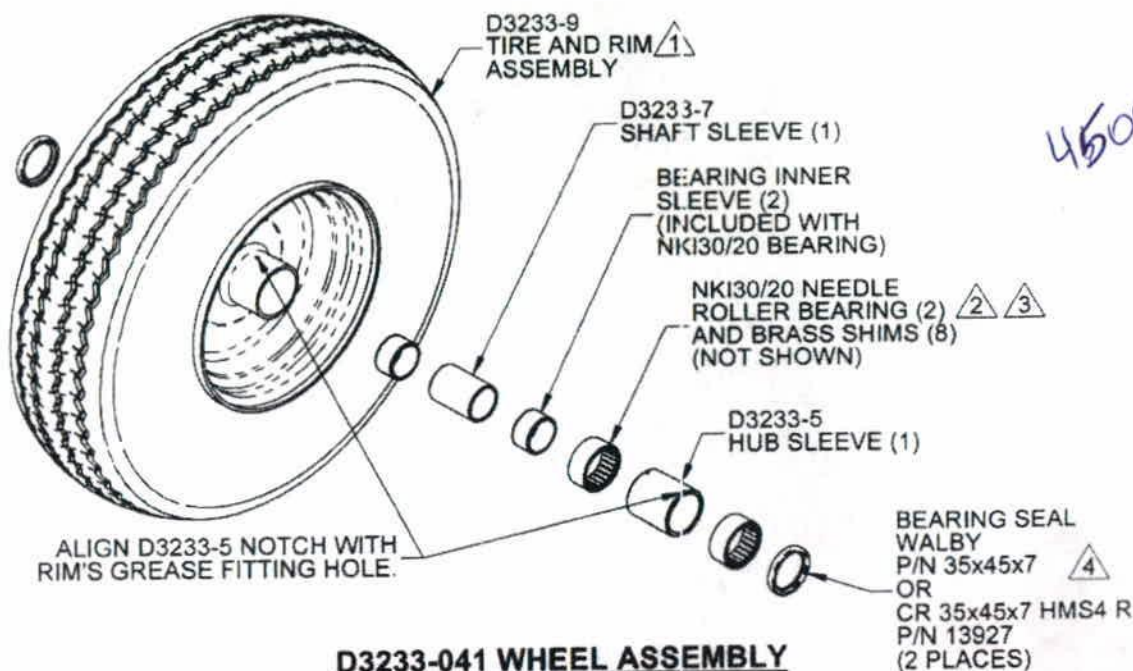
DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. <b>D3233</b>	REV. 1 SHEET 1 OF 1
DATE	05.03.08	TITLE <b>WHEEL ASSEMBLY</b>	SCALE 1
A	05.02.18	NEW ISSUE	
B	05.03.08	ADDED BEARING SEALS	



RELEASED  
05/05/08

WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*

\* MANUFACTURER'S RECOMENDATIONS  
ARE 75 PSI FOR HIGH SPEED USE.



### D3233-041 WHEEL ASSEMBLY

#### NOTES:

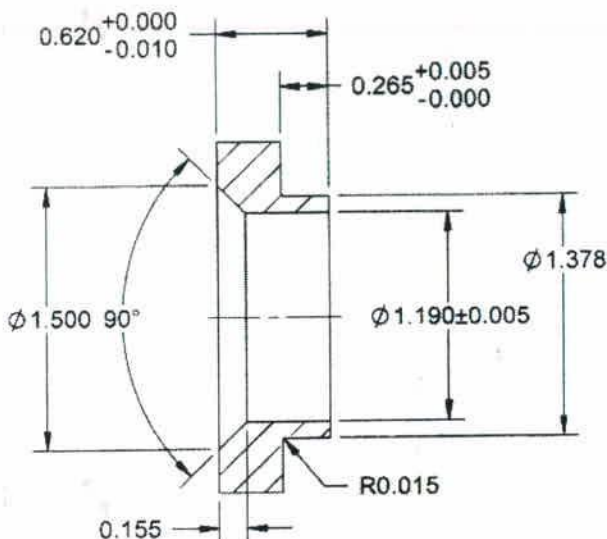
- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 8353T74
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH  
(4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT.
- 4) POSSIBLE SUPPLIER: GENERAL BEARING
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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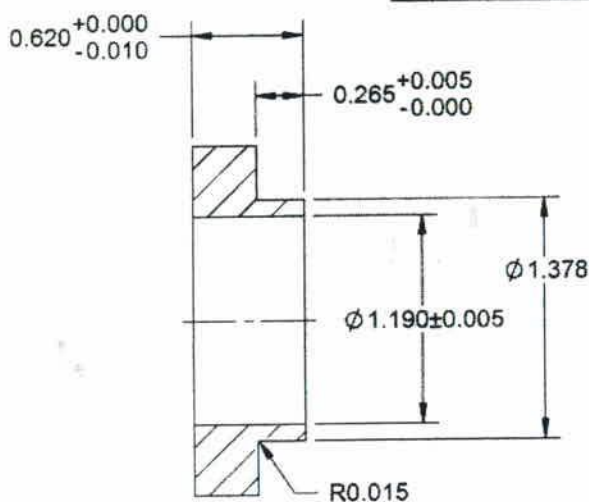
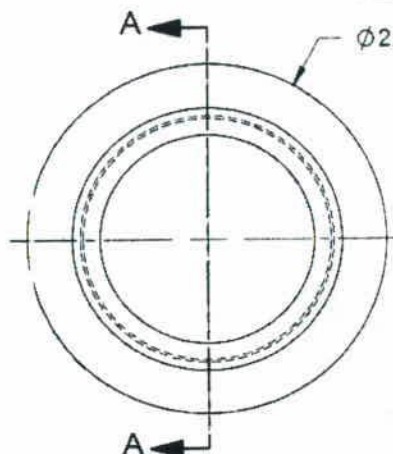


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3233</b>	REV 3 SHEET 2 OF 3
DATE <b>05.03.08</b>		TITLE <b>WHEEL ASSEMBLY</b>	SCALE 1:1



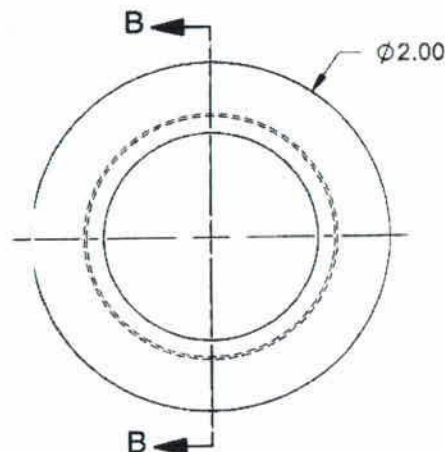
**SECTION A-A**

**D3233-1 INSIDE WASHER**



**SECTION B-B**

**D3233-3 OUTSIDE WASHER**



**NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00  
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS  
(REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

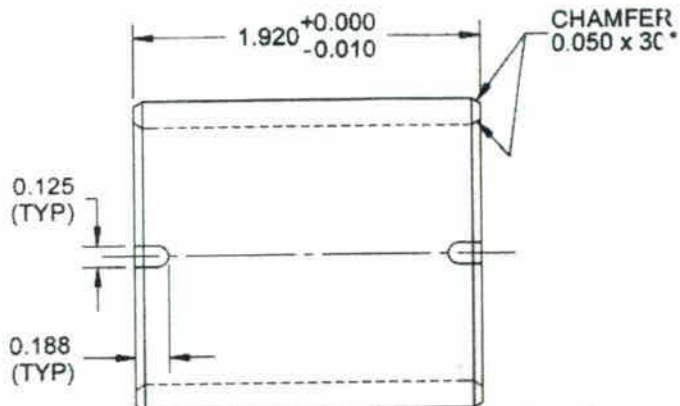
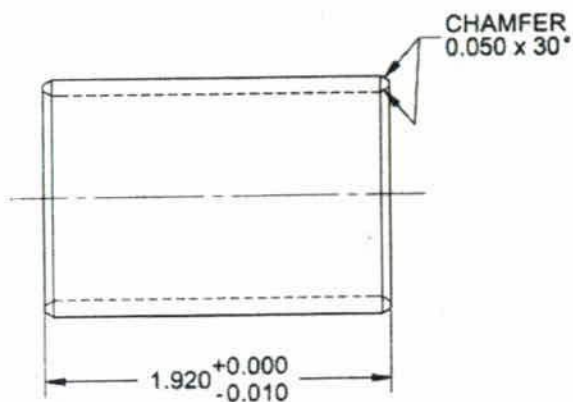
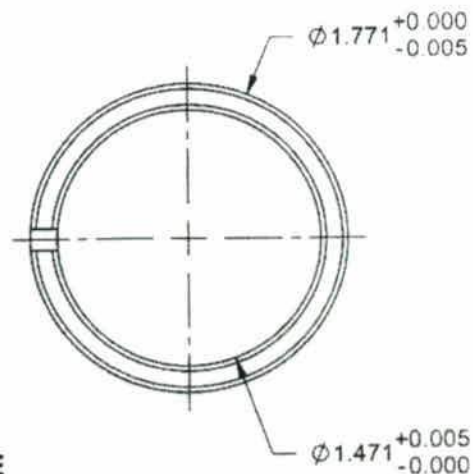
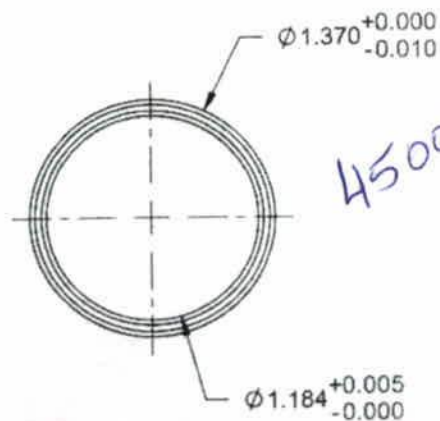
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3233</b>	REV. 1 SHEET 3 OF 3
DATE <b>05.03.08</b>	TITLE <b>WHEEL ASSEMBLY</b>		SCALE 1

**D3233-5 HUB SLEEVE****D3233-7 SHAFT SLEEVE****NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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Purchase Order  
**PO00008012**

Page 2 of 2

200 Aurora Industrial Pkwy  
Aurora OH 44202-8087  
330-955-5500  
cle.sales@mcmaster.com

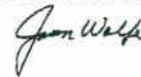
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawkesbury ON K6A 1K7  
Canada  
Attention: Main Finished Goods Location

McMaster-Carr Number  
**2510465-01**

01/21/2009

Certificate of compliance

This is to certify that the above items were supplied in accordance with the description and as illustrated in the catalog.



Jason Wolfe  
Compliance Manager



Purchase Order  
PO00008012

Page 1 of 2

200 Aurora Industrial Pkwy  
Aurora OH 44202-8087  
330-991-5500  
cle.sale.s@mcmaster.com

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawkesbury ON K6A 1K7  
Canada  
Attention: Main Finished Goods Location

McMaster-Carr Number  
2510465-01

01/21/2009

Line	Description	Ordered	Shipped	228 lbs
3	83 13T74 Pneumatic Wheel with One-Piece Rim, 18" X 5.9", center Hub, 1-1/4" Axle, Roller Bearing, 159C#cap	20 Each	15 8 - 69 - 41 02 - 68 T74 228 lbs Sorkulac	15 EA 3

Shipped separately from our Cleveland warehouse on 01/21

1	95 106A170 Nylon 6/6 Small-OD Flat Washer, 7/16" Screw Size, 1/2" ID, 11/16" OD, .028"-.034" Thickness	1 Pack	1
2	93 195K88 Neoprene/Vinyl/Buna-N Foam Rubber Strip, Adhesive-Back, 1/4" Thick, 1" Width, 50' L, Black	1 Each	1
3	83 13T74 Pneumatic Wheel with One-Piece Rim, 18" X 5.9", center Hub, 1-1/4" Axle, Roller Bearing, 159C#cap	20 Each	5
4	98 15K217 Nylon T-Strainer, Clear Bowl, 3/4" NPT Female, 40 X 36 Mesh Screen	1 Each	1
5	90 161A164 Helical Insert Installation Tool, 3/8"-24 Internal Thread, Style A	1 Each	1

Dart Aerospace Ltd

EXP

Cycle

27



228 lbs  
1 line

EW1BSP54  
01/21/2009  
09:36/10:56  
066

